

Date: Wednesday, 25/06/2008 12:00:15 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206L /407 STEP ASSY, LH		
Job Number	: 40088			Part Number	: D2724041		
Estimate Number	: 11702			Drawing Number	: D2724 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 25/06/2008 S.O. No. :			Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 09/07/2008 Qty: 5 Um: Each		
Previous Run	: 39837A						
Written By	:						
Checked & Approved By	: <u>JLD 08.06.25</u>						
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Qty Part # Description Batch:	
		1 D2622-120C Extrusion <u>B 39316</u>	
		Check Material for any Dents or Defects	
			<u>SAD 08/06/27</u> (5)
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		Cut D2724-1 using D2622 extrusion as per Dwg D2724	
		Deburr and bevel ends for welding	
3.0	D2734	Step End Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		206 Step Endplate	
		Pick:	
		Qty Part Number Description Batch	
		2 D2734 End Cap <u>B 34520</u>	
4.0	D34581	Step Mounting Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D3458-1 Plate <u>B 3545 5X</u>	
			<u>B 3648 5X</u> ✓ <u>08-07-09 SP</u>

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date &amp; initial all entries

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Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 40088

Part Number: D2724041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D34583	Step Mounting Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-3	Plate	<del>20083</del> B351416 10x1 08-07-09 SP

6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

PTD

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD Batch:

~~M 107-678~~  
M 106834

Grind end cap welds flush

↳ SAD 08/07/14 (5)

~~08-07-09~~  
08-07-09 SP

5X

7.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

PD 08-07-29 (5)

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/07/09 (4524)

9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Fx 08/07/29

(5)

10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 08/07/30 5

11.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

~~08/07/29~~

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2724-011 PAR #: N/A Fault Category: Prod / Prod - L5 NCR:  Yes No DQA: D Date: 08/08/07  
D27L - 628 QA: N/C Closed: D Date: 08/08/08

WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC Section A	Corrective Action			Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
07/28	6.0	all 4 steps have <del>the</del> Both end caps welded on Prior to shuttle R.C new welder <del>mounting</del> stated instruction and D.D. not <del>read</del> follow up correctly.	<u>RS/MS/2</u>	Remove 1 end cap on each step, Ensure length is as per drawing <u>baseline revision</u>	<u>RS/MS/2</u> 08/07/28	<u>RS/MS/2</u> 08/07/28	<u>RS/MS/2</u> 08/07/28	<u>RS/MS/2</u> 08/07/28	<u>RS/MS/2</u> 08/07/28
			<u>RS/MS/2</u>	Ensure to follow and read all work instructions, Especially when driving the part for the 1st time.					

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Part Number: D2724041

Job Number:



Seq. #:	Machine Or Operation:	Description :
	Weld Remaining end cap as per Dwg D2724 using Jig DT DT A/R AL ROD Batch: <u>11086834</u>	followed by Jig
12.0	QC9	Grind per dwg D2724 → <u>SPD 08/07/30 (5)</u> <u>SPD 08-07-30</u> <u>5X</u> VISUAL WELDING INSPECTION
13.0	QC5	Comment: VISUAL WELDING INSPECTION <u>PD 08-07-30 (5)</u> INSPECT WORK TO CURRENT STEP
14.0	HAND FINISHING1	Comment: INSPECT WORK TO CURRENT STEP <u>S 08/07/30 x5LH</u> <u>5X LH</u> HAND FINISHING RESOURCE #1
15.0	POWDER COATING	Comment: HAND FINISHING RESOURCE #1 Touch up Alodine <u>m-f 08/07/31</u> POWDER COATING <u>M108523</u> <u>5XLH</u>
16.0	QC3	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: <u>10:00</u> OVEN TEMPERATURE: <u>320 01</u> FINISH TIME: <u>10:30</u> <u>m-f 08/07/31</u> INSPECT POWDER COAT/CHEMICAL CONVERSION
17.0	HAND FINISHING1	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <u>Fd 08/07/31 (5)</u> HAND FINISHING RESOURCE #1 <u>m108496</u>
18.0	QC3	Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4 INSPECT POWDER COAT/CHEMICAL CONVERSION <u>B 08/07/31 (5)</u> <u>8/8/6</u> <u>SG</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Customer: CU-DAR001 Dart Helicopters Services

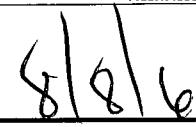
Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 40088

Part Number: D2724041

Job Number:



Seq. #:	Machine Or Operation:	Description :
19.0	PACKAGING 1	PACKAGING RESOURCE #1 
20.0	QC21	FINAL INSPECTION/W/O RELEASE 
		Comment: FINAL INSPECTION/W/O RELEASE  

Job Completion



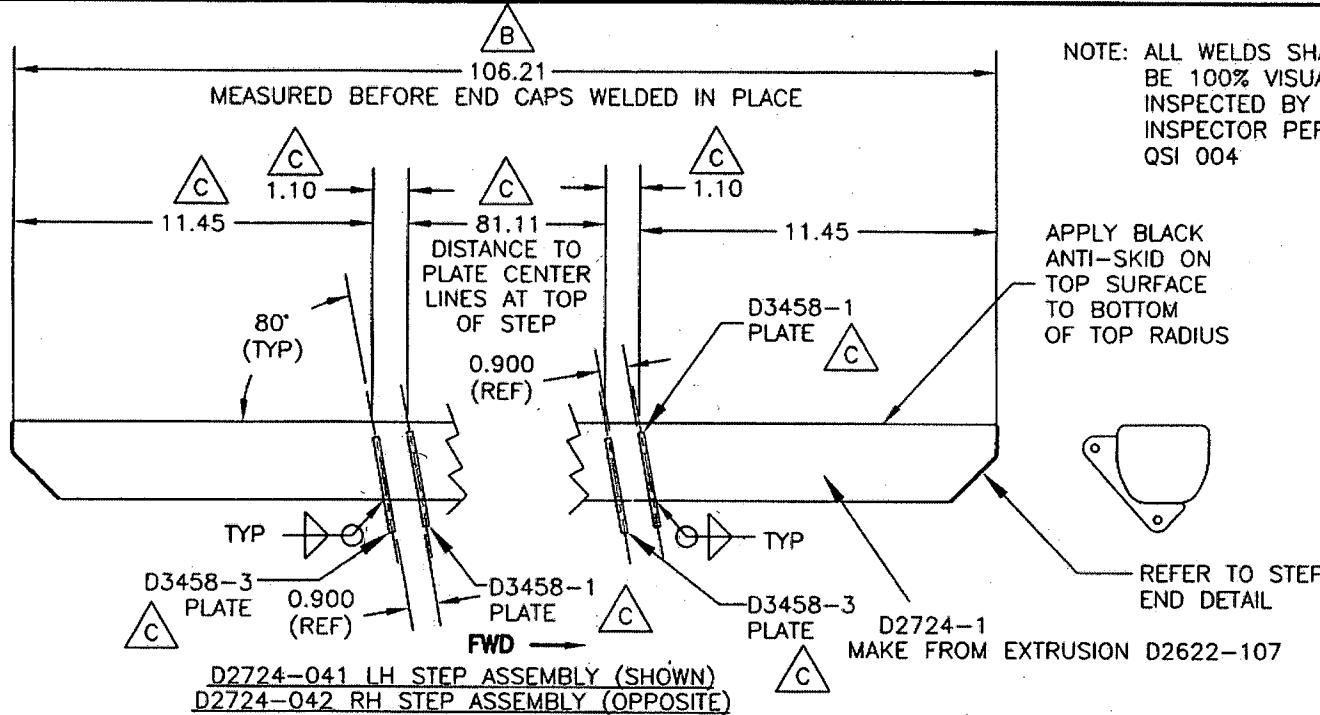
MF 08-08-07

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng					

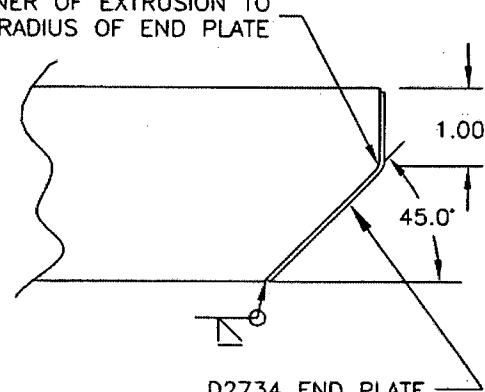
NOTE: Date & initial all entries



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
X		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

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WITHOUT NOTICE  
N. 400088



TYPICAL STEP END DETAIL  
NOT TO SCALE



D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC.
		PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D2724
DATE		REV. C
05.09.19		SHEET 1 OF 1
A	97.12.04	TITLE
		206L/407 STEP ASSEMBLY
B	98.10.19	SCALE
		NTS
C	05.09.19	
		UPDATED WELD DETAIL REVISED TOLERANCES
		RE-DESIGN, ADD D3458-1/-3

